












Date: Monday, 9/10/2007 1:18:54 PM
 User: Kim Johnston

Process Sheet



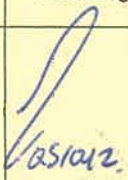

split 2

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 34474 -2	
Estimate Number : 12578	
P.O. Number : N/A	Part Number : D3560041
This Issue : 9/10/2007 S.O. No. : N/A	Drawing Number : D3560 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : B/C
Previous Run : 33844	Material : N/A
Written By : _____	Due Date : 9/17/2007
Checked & Approved By : _____	Qty: 5/12 Um: Each
Comment : Est Rev:A New Issue 07.05.24 EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M6061T6B0500X05000 6061-T6 Bar 50" x 5.0"
 	
Comment: Qty.: 1.4648 f(s)/Unit Total: 17.5770 f(s) 6061-T6 Bar 0.50" x 5.00" Batch: M105646 <i>mk 07/09/20</i> (12)	
2.0	BAND SAW BAND SAW
 	
Comment: BAND SAW Cut blanks 16.750" long <i>mk 07/09/20</i> (12)	
3.0	HAAS1 HAAS CNC VERTICAL MACHINING #1
 	
Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA693 Rev: AA & Dwg D3560 Rev: C 2-C'sink 0.196" hole on manual mill as per dwg D3560 3-Deburr per dwg D3560 <i>SL 07/09/21</i> (12)	
4.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
 	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>SL 07/09/21</i>	
5.0	QC8 SECOND CHECK
 	
Comment: SECOND CHECK <i>SL 07-09-21</i> (12)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/21	3	- 1 arm scrapped, moved while roughing outside profile - bolts were not tight enough human error		- scrap & replace	J.L 07/09/21	 07/09/21		 07/09/21

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34474

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

PLATE

~~33460~~ 334260 334478 (5)

07-10-25
07-10-10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

07-10-25
07-10-10

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/26

07-10-25

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-10-26 (5)
07-10-10

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-10-26
07-10-10

(5)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07/10/26

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/10/26

(5X)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07-10-26 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
01-10-25	1.	1. weld assembly as per diag. D3560 part should be pre heated to 60-70 celcius (before) before welding arm to bracket.	<i>[Signature]</i>	01.10.25		<i>[Signature]</i> 07.10.25	<i>[Signature]</i> 02.10.25

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:18:54 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34474

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2011/10/25

Job Completion



4 7-10-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

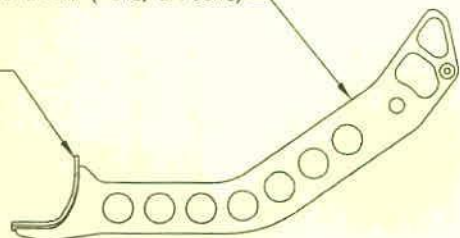
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3560-1 ARM (-041, SHOWN)
OR D3560-2 ARM (-042, OPPOSITE)

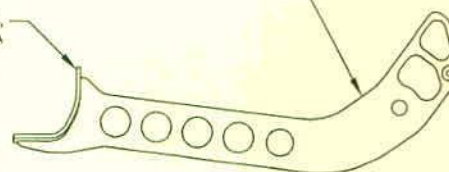
D3592-1 PLATE,
SEE DETAIL A



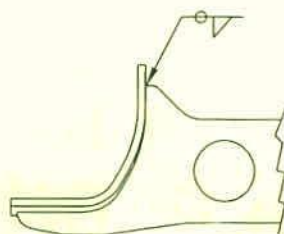
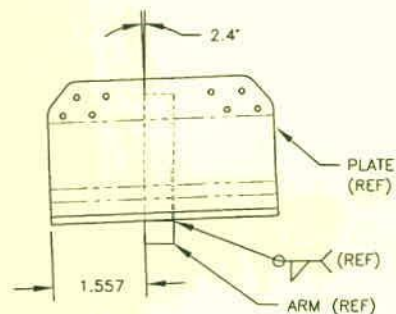
D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)

D3560-3 ARM (-043, SHOWN)
OR D3560-4 ARM (-044, OPPOSITE)

D3592-1 PLATE,
SEE DETAIL A



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.19

C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	GP	DRAWN BY GP
CHECKED	H	APPROVED H
DATE	07.06.19	TITLE
		ARM WELDMENT
		DART AEROSPACE LTD.
		MARKHAM, ONTARIO, CANADA
		DRAWING NO. D3560
		REV. C
		SHEET 1 OF 3
		SCALE 1:4

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OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

NO. 34474
WORK ORDER
UNCONTROLLED COPY
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WITHOUT NOTICE
RETURN TO
ENGINEERING
SHOP COPY

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ASTOR LENOX TILDEN FOUNDATION
1900

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PLATE 1018077ED CAROL

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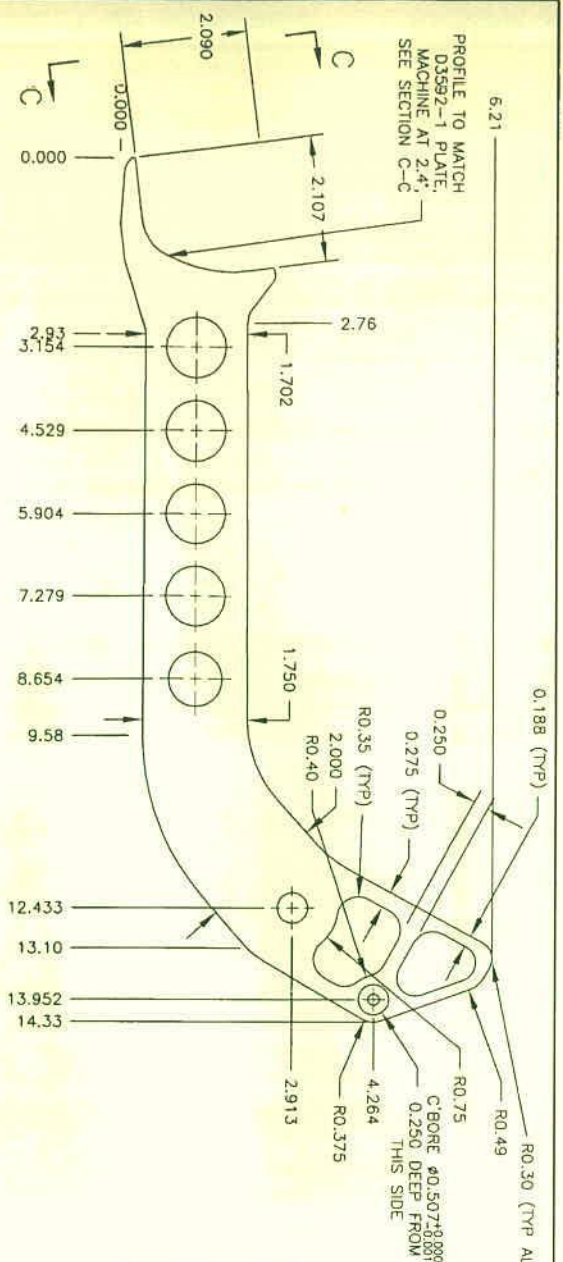
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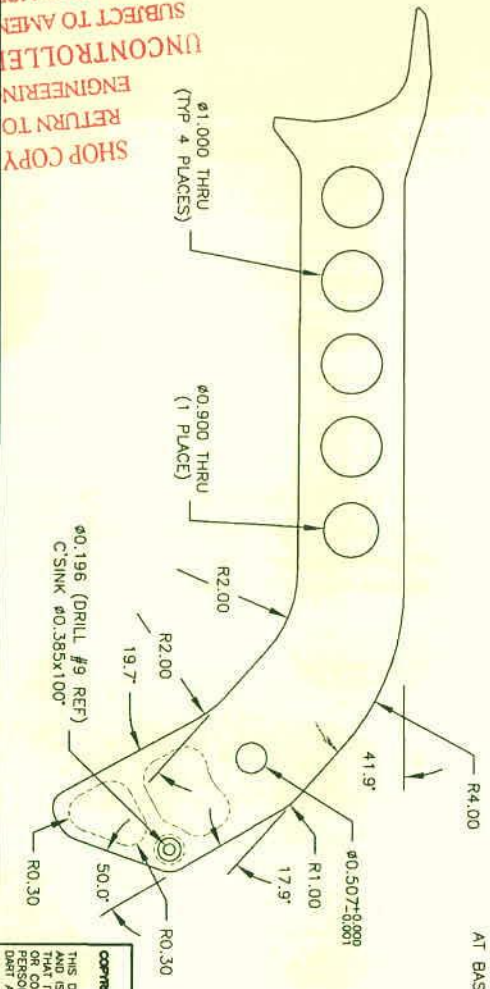
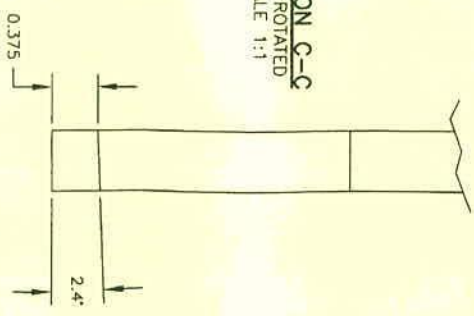
PLATE 1018077ED CAROL

NO. 34474
 WORK ORDER
 WITHOUT NOTICE
 SUBJECT TO AMENDMENT
 UNCONTROLLED COPY
 RETURN TO
 ENGINEERING
 SHOP COPY



- D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)**
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK (QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION C-C
 VIEW ROTATED
 SCALE 1:1



DESIGN		DRAWN BY		DART		DART AEROSPACE LTD.	
CHECKED	APPROVED	CHECKED	APPROVED	DRAWING NO.	REV. C	SHEET 3 OF 3	SCALE
07.06.19				D3560			1:2
				ARM WELDMENT			

RELEASED
 07.06.19

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